












split

Date: Tuesday, 22/08/2006 7:41:31 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Job Number : 25804 Estimate Number : 12100 P.O. Number : N/A This Issue : 22/08/2006 S.O. No. : N/A Prsht Rev. : NC First Issue : 09/02/2006 Type : PURCHASED PARTS Previous Run : N/A Written By : _____ Checked & Approved By : _____ Comment : est rev. A new issue EC		Drawing Name : WHEEL ASSEMBLY Part Number : D3397041 Drawing Number : D3397 REV.A Project Number : N/A Drawing Revision : A Material : N/A Due Date : 31/03/2006		Qty: 16 Um: Each
Additional Product				
Job Number: 				
Seq. #:	Machine Or Operation:	Description :		
1.0	D3397041	wheel ass'y		
 				
Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s) wheel ass'y <i>B25804(16) M19250 (4)</i>				
2.0	OUTSIDE SERVICE	OUTSIDE SERVICES		
 				
Comment: Sub-Contracting PURCHASING Issue P/O: <i>1884</i> <i>C206108/22</i> Order Part #4997T28 from McMaster-Carr as per DwgD3397 Ensure Certificate of Conformity is attached <i>(16)</i> <i>(P10)</i>				
3.0	QC6	DIMENSIONAL CHECK		
 				
Comment: DIMENSIONAL CHECK Ensure certification comply to Dwg D3397 <i>J060825 (15)</i> <i>10/8/29 (16)</i>				
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1		
 				
Comment: LARGE FABRICATION RESOURCE 1 1-Remove retainers and bearing from wheel, do not damage retainers, discard bearing. <i>16+</i> 2-Ship retainers to machining <i>CPL 06-08-26 4+M19250</i> <i>(20)</i>				
5.0	LATHE CONV.	CONVENTIONAL LATHE		
 				
Comment: CONVENTIONAL LATHE 1-Turn as per Dwg D3397 2-Deburr <i>06/08/29</i> <i>19.5</i> <i>NOTE: 2 per Assy</i> <i>P10</i>				

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-25	2.1	Receive and inspect. attach certificate of compliance perm. change as shown		6/8/24	16		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/09/07
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/08/24	5.0	INSIDE BORE Dia. oversize, Retainer IS SCRAP QTY 1. CUT Twice as Much Req'd During Boring operation.		destroy: No Replace	 06/08/24	 06-06-24		 06-06-24

NOTE: Date & initial all entries

Date: Tuesday, 22/08/2006 7:41:31 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL ASSEMBLY

Job Number: 25804

Part Number: D3397041

Job Number:



Seq. #:

Machine Or Operation:

Description :

IDENTIFY AS D3397-3

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 06/08/29

7.0

D33975

sleeve



Comment: Qty.: 1.0000 (s)/Unit Total : 16.0000 (s)

Pick:

Qty Part number Description batch
1 D3397-5 sleeve

54 12+ B26325 B27570 Cpl 06-08-29

(17)

8.0

HK2820

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part number Description batch
2 HK2820 bearing

12 20 M17496 M101988 Cpl 06-08-29

(17)

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Assemble bearing, sleeve and retainers as per dwg D3397

Cpl 06-09-06

(17)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206-09-06 17

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *07*

Cpl 06/9/06

(17)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/07

(17)

Job Completion



u 06-09-06

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7 1270 ABERDEEN ST
HAWKESBURY ON K6A 1

YOUR PURCHASE
ORDER NUMBER
P000001884
Today's Date: 8/22/06

McMASTER-CARR
200 AURORA INDUSTRIAL PKWY
AURORA OH 44202
IF THERE ARE ANY QUESTIONS ABOUT THIS
SHIPMENT CONTACT OUR SALES DEPARTMENT
(330)995-5500

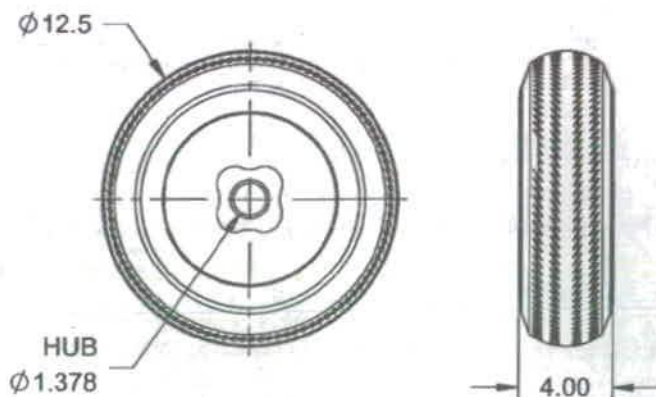
PAGE
1 OF 1
MCM NUMBER
3046380-01

Warehouse Location	McMaster Carr Part Number	Fill Quantity	Item Description	Your Line	Your Order	This Shipment
8- 21-38	84-69 4997 T28	16 EA	PNEUMATIC WHEEL WITH BOLTED RIM 12.4" DIA X 3.6"W, 1" AXLE, ROLLER BRNG, 440W CAP 131 RAS	1	16 EA	16

McMASTER-CARR PACKING LIST

DART

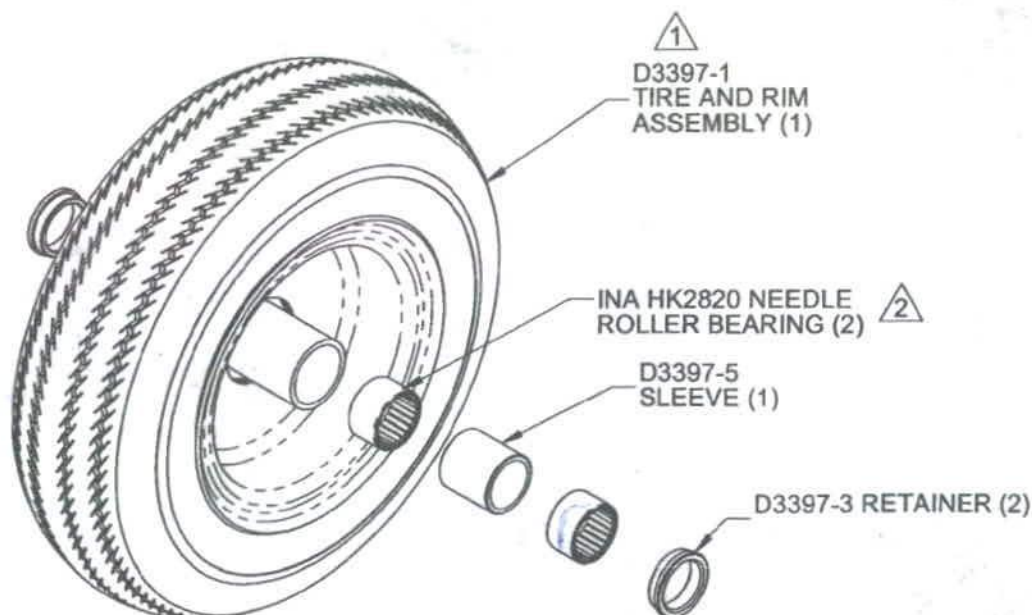
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3397	REV. A SHEET 1 OF 3
DATE 05.02.10	TITLE WHEEL ASSEMBLY		SCALE 1:8
A	05.02.10	NEW ISSUE	



1 D3397-1 TIRE AND RIM ASS'Y

REFERENCE ONLY

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: $\phi 12.4 \times 4.1$ RIM: $\phi 6.0 \times 4.0$	445 LBS	50 PSI*

RELEASED
[Signature]
06/03/07

D3397-041 WHEEL ASS'Y

NOTES:

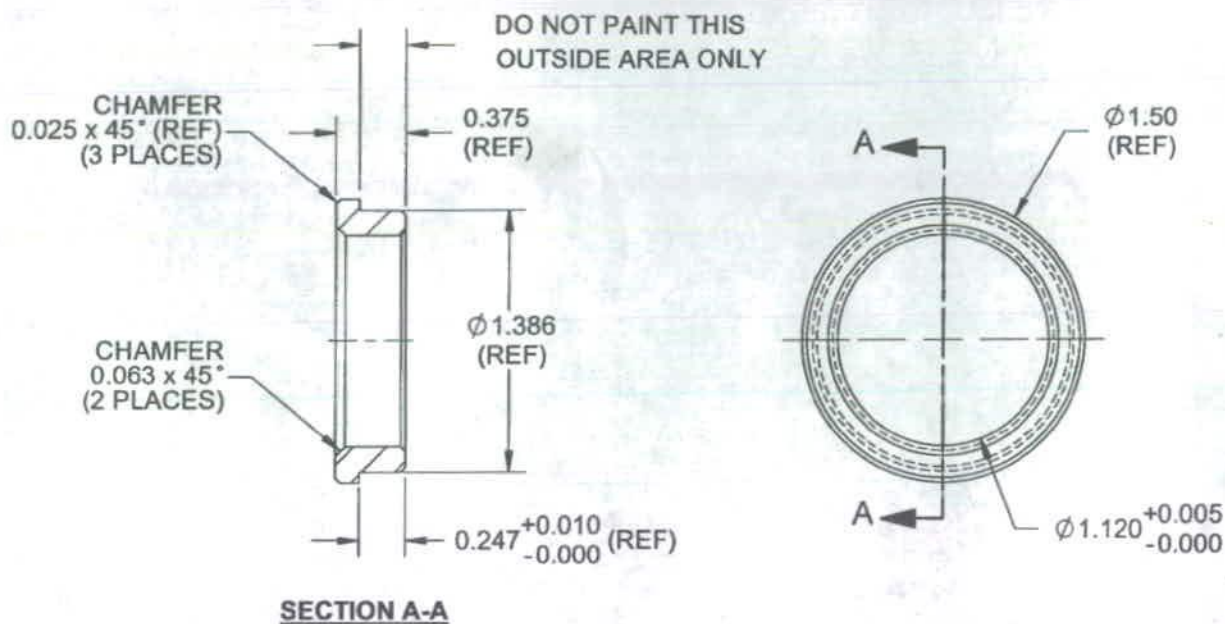
- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 4997T28. SCRAP ORIGINAL BEARING
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) INFLATE TIRE TO MAX. 50 psi
- 7) APPLY RUST INHIBITOR NOT PROTECTED BY PAINT. RUST INHIBITOR P/N: LPSC30316

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3397	REV. A SHEET 2 OF 3
DATE 05.02.10	TITLE WHEEL ASSEMBLY		SCALE 1:1

RELEASED
06/03/09**REFERENCE ONLY****SPECIFICATION CONTROL DRAWING****D3397-3 RETAINER****NOTES:**

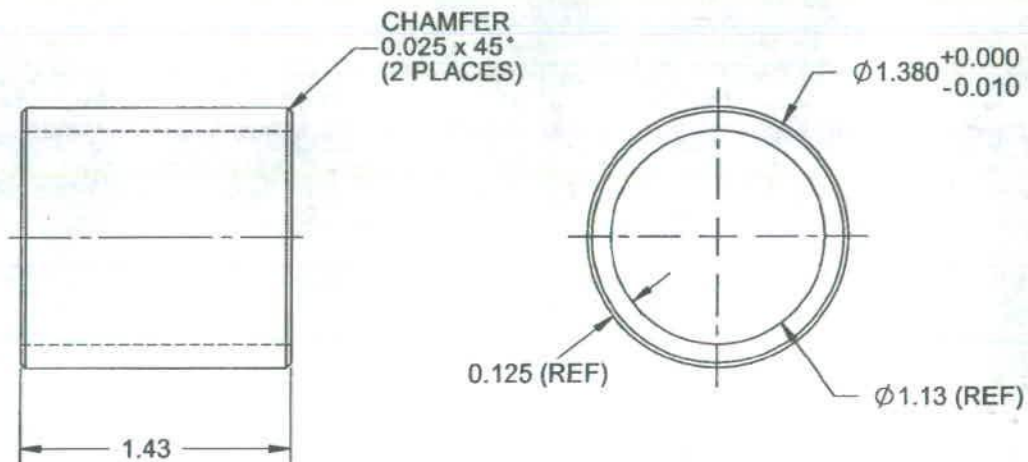
- 1) MATERIAL: REMOVE FROM McMASTER-CARR P/N 4997T28 AND MODIFY AS SHOWN
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.025

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3397	REV. A SHEET 3 OF 3
DATE 05.02.10	TITLE WHEEL ASSEMBLY		SCALE 1:1

RELEASED
06/03/09**REFERENCE ONLY****D3397-5 SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR1.375W.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.025

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